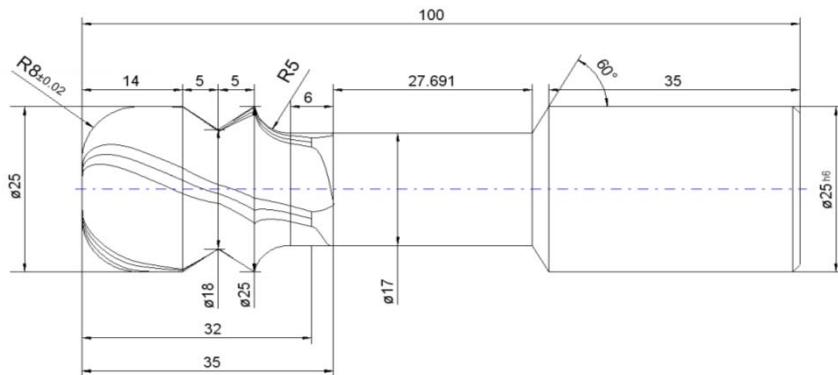


Profiled Milling Cutter Ø25 Z4

A02-001



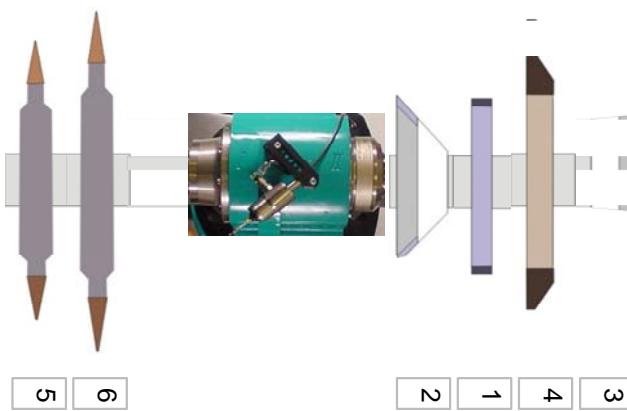
1. Cycletime for Production

Workpiece:	Ø25 Ltot 100, LC 35 mm Material CARBIDE									
Operations	Probe	Flute 1	Flute 2	Gashing	End 2	End 1	PlungRough	Pregrd clr 2	Finish clr 2	Finish clr 1
Feed [mm/Min]	2000	40	100	80	70	100	25	50	60	80
Power [kW]		3	2	2	1	1	4	3	2	2
Cutting speed [m/s]	18	32	20	22	22	32	32	32	32	32
Used wheels		1	1	2	3	4	4	5	6	6
Grinding time [s]	12	260	117	75	66	48	382	200	170	132
Total cycle time	24 Min 22									

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	11V9 Ø75 D64
4	1V1 Ø125 D64
5	14EE1 Ø150
6	14EE1 Ø200 D76V20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories:

Responsible OP, 27.2.14

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TECHNOLOGY
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